

Work Order ID 136635-1

136635

Page 1

Thursday, September 03, 2015 8:18:52 AM

Item ID: D4704-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Expandable Pin Assembly
 Start Date: 9/1/2015 Start Qty: ~~4.00~~ ³ *4* Cust Item ID:
 Required Date: 9/1/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: SEP 04 2015 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4704	A								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG USE DT9882, DT9883								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
OCT 01 2015

3x 15/10/11 DAS
36
9-89

(3) DAS
38
9-89
OCT 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause				FAULT CATEGORY																					
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Required Date: 9/1/2015 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location. <i>st 123</i>	0.00							
140									
Packaging	Memo	0.00				<i>3</i>	<i>9-8-15</i> <i>27</i> <i>AS</i>		
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00				<i>ML5</i>		<i>OCT 01 2015</i>	
Quality Control									

SH 20151001

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, September 03, 2015 8:18:58 AM

Page 1

Work Order ID: 136635

136635

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS
12.10.16 AS PER DWG REV.A DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 *D4708-1* Lanyard		Manufactured	No			110	Each	29.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		29							
				126258		29							
D4709-1 *D4709-1* Spring Clip		Manufactured	No			110	Each	8.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		8							
				134344		2		B136461					
				135428		6							
D4711-041 *D4711-041* Expandable Pin Assembly, Modified		Manufactured	No			110	Each	4.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		4		B136623					
				134477		4							
MS20613-4C8 *MS20613-4C8* Rivet		Purchased	No			110	Each	222.0000	4	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		222							
				120242		222							

MS20613-4C7

M129036

6x

15/10/01

DAS
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OCT 01 2015

15/10/01

DAS
36
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DQA: _____ Date: _____

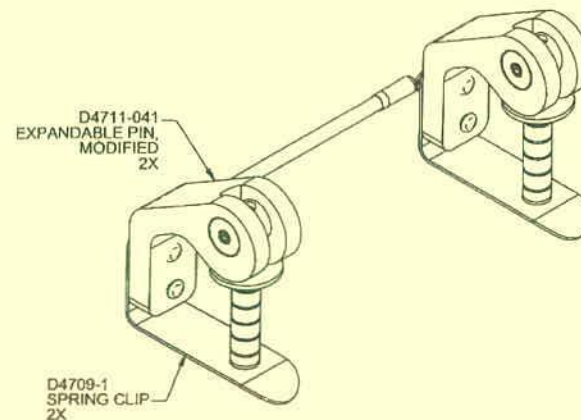
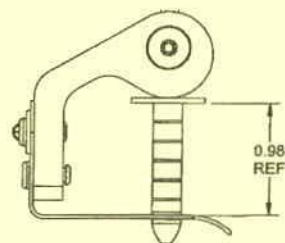
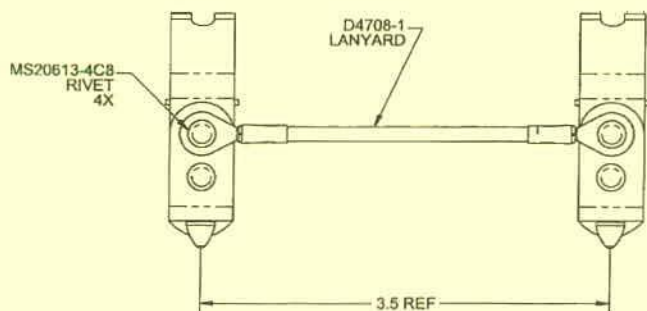
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4704-041	EXPANDABLE PIN ASSY
1	2	D4711-041	EXPANDABLE PIN, MODIFIED
2	1	D4708-1	LANYARD
3	2	D4709-1	SPRING CLIP
4	4	MS20613-4C8	RIVET



136635 MLJ
150904

D4704-041 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4704-041" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.39 lbs

A NEW ISSUE		RP	12.09.19
REV	DESCRIPTION		BY DATE
DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	RP	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4704	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		EXPANDABLE PIN ASSY	NTS
DATE 12.09.19		COPYRIGHT © 2012 BY DART AEROSPACE USA, INC.	
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11 2012-10-12